



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 186852



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Large Fab-5		MM
100	Large Fab	1 pcs		12/7/18	0.00	10.00	Large Fab 1		CPC 8/01/2019
110	QC	1 pcs		12/7/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs		12/7/18	0.00	0.29	HandFinish2		DR 19-01-09
130	Powdercoat	1 pcs		12/7/18	0.00	0.93	Powdercoat2		DR 19-01-09
135	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging1		BEB 19-01-10
140	QC	1 pcs		12/7/18	0.00	0.00	QC3		BEB 19-01-10
150	HandFinish	1 pcs		12/7/18	0.00	0.50	HandFinish4		BEB 19-01-10
160	QC	1 pcs		12/7/18	0.00	0.00	QC5		JAN 10 2019 68
170	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3-2		BEB 19-01-10 9-89
180	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		JAN 10 2019

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138951 START: 2:00 OUT: 3:50 FINISH: 2:15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 Ea (2 ea) ✓	90-Start up Operation	5125 289
D3913-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5123 779
D3913-15 ✓	Wide Handle Plate	1 Ea (1 ea) ✓	90-Start up Operation	5115 269
D3913-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5124 101
D3913-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5136 111
D3913-9 ✓	Hinge Rib	1 Ea (1 ea) ✓	90-Start up Operation	5133 177
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5138 951
D3916-5 ✓	Light Rib	3 Ea (3 ea) ✓	90-Start up Operation	5137 213
D4016-1 ✓	Hinge Half, Base	3 Ea (3 ea) ✓	90-Start up Operation	2x 5112 356 / 1x 5115 309
D4017-7 ✓	Rib	3 Ea (3 ea) ✓	90-Start up Operation	5123 991
D4017-9 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5134 676

007295

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under toleranc ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5133427
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5126559
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5138258
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5138521
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5126705
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5109204
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5106952
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5133206-1
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5118039
NAS1149F0332P Washer		2 ea	150-HandFinish	5136368-1

Job Allocations

M.U. 007424

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	58	0
	D3913-1	1	8	0
	D3913-15	1	12	0
	D3913-3	1	8	0
	D3913-7	2	10	0
	D3913-9	1	5	0
	D3916-041	2	8	0
	D3916-5	3	9	0
	D4016-1	3	196	0
	D4017-7	3	38	0
	D4017-9	2	8	0
	D4020-11	2	13	0
	D4021-1	3	36	0
	D4034-041	1	3	0
		1	3	0
		2	24	0
		33	2,292	0
		6	144	0
		2	910	0
		2	23	0
		2	301	0
		6	2,282	0
		12	851	0

ications

id not be found.



Container No: S141583



Part: D3913-041

Job No: 186852

Serial No/Batch: S141583

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/03/19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____			MRB (QS1042) Approval
Description Work Order Deviation		Disposition			Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under toleranc ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____			